

Ship March 16

Work Order ID 77184

77184

Page 1

November-28-11 9:04:24 AM

Item ID: D3531-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket Assembly
 Start Date: 28/11/2011 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 12/12/2011 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/11/12 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3531	Rev A

100		0.00
100	Small Fab	
Small Fab	Memo	0.00
Small Fab	Assemble as per dwg D3531	

12/03/12 (6)

110	QC5- Inspect part completeness to step on W/O	0.00
110		
QC	Memo	0.00
Quality Control		

5/26/12

(16)

120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00
120		
Powdercoat	Memo	0.00
Powder Coating		

START TIME: 12h55 OVEN TEMPERATURE:
1h25 FINISH TIME: 320°F 11/15/12

6 12/03/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID: 77184

77184

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November-28-11 9:04:24 AM

Item ID: D3531-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket Assembly

Start Date: 28/11/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <i>ST227</i>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

6 6 12/10 3/12

(6x) SP 12-03-13

12/3/14

12-3-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November-28-11 9:04:28 AM

Page 1

Work Order ID: 77184

Parent Item: D3531-041

Parent Item Name: Bracket Assembly

77184

D3531-041

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3531-1		Manufactured	No			100	Each	1.0000	1	6			
D3531-1													
Bracket													

Location Loc Qty Loc Code

GA 1
71977 1

D3531-3		Manufactured	No			100	Each	1.0000	1	6			
D3531-3													
Bracket Front Plate													

Location Loc Qty Loc Code

GA 1
61781 0
71978 1

MS20470AD4-4		Purchased	No			100	Each	4,178.000	12	72			
MS20470AD4-4													
Rivet, Universal Head													

Location Loc Qty Loc Code

ST319 4178
116188 136
116391 66
118614 1190
119109 2000
119386 786

EP 12/03/12
B 77700 (5x)

EP 12/03/12
B 77575 (6x)

EP 12/03/12
M 120518 (72x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

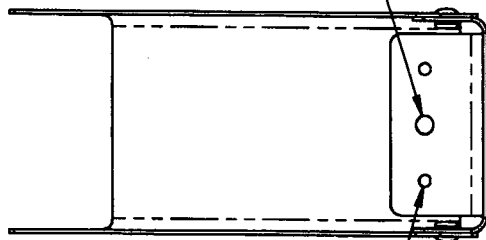
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	

4
TRANSFER DRILL #9 ($\phi 0.196$)



TRANSFER DRILL #30 ($\phi 0.129$)
INSTALL MS20470AD4-4 RIVET
(2 PLACES)

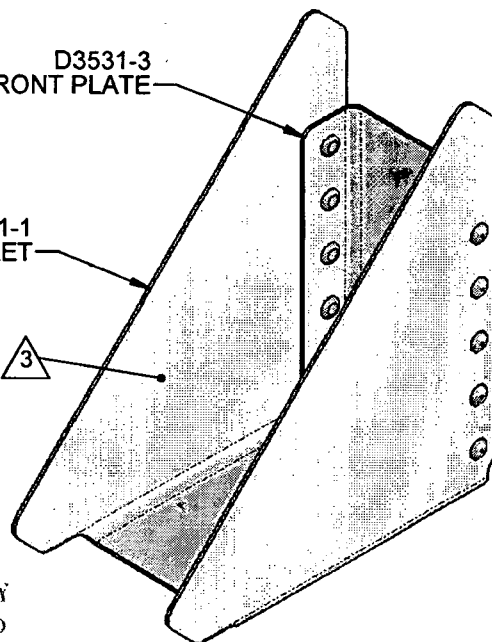
4

RELEASED
07-08-03

D3531-3
BRACKET FRONT PLATE

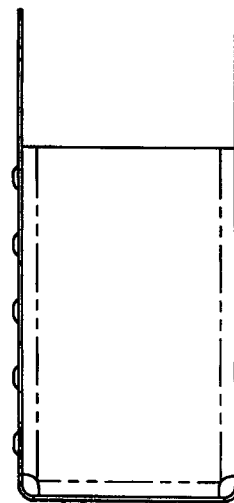
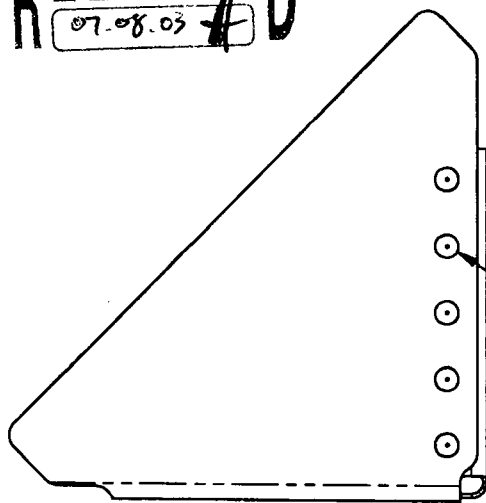
D3531-1
BRACKET

3



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37184 M.L.J
11/11/28

MS20470AD4-4
(10 PLACES)



D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET.
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

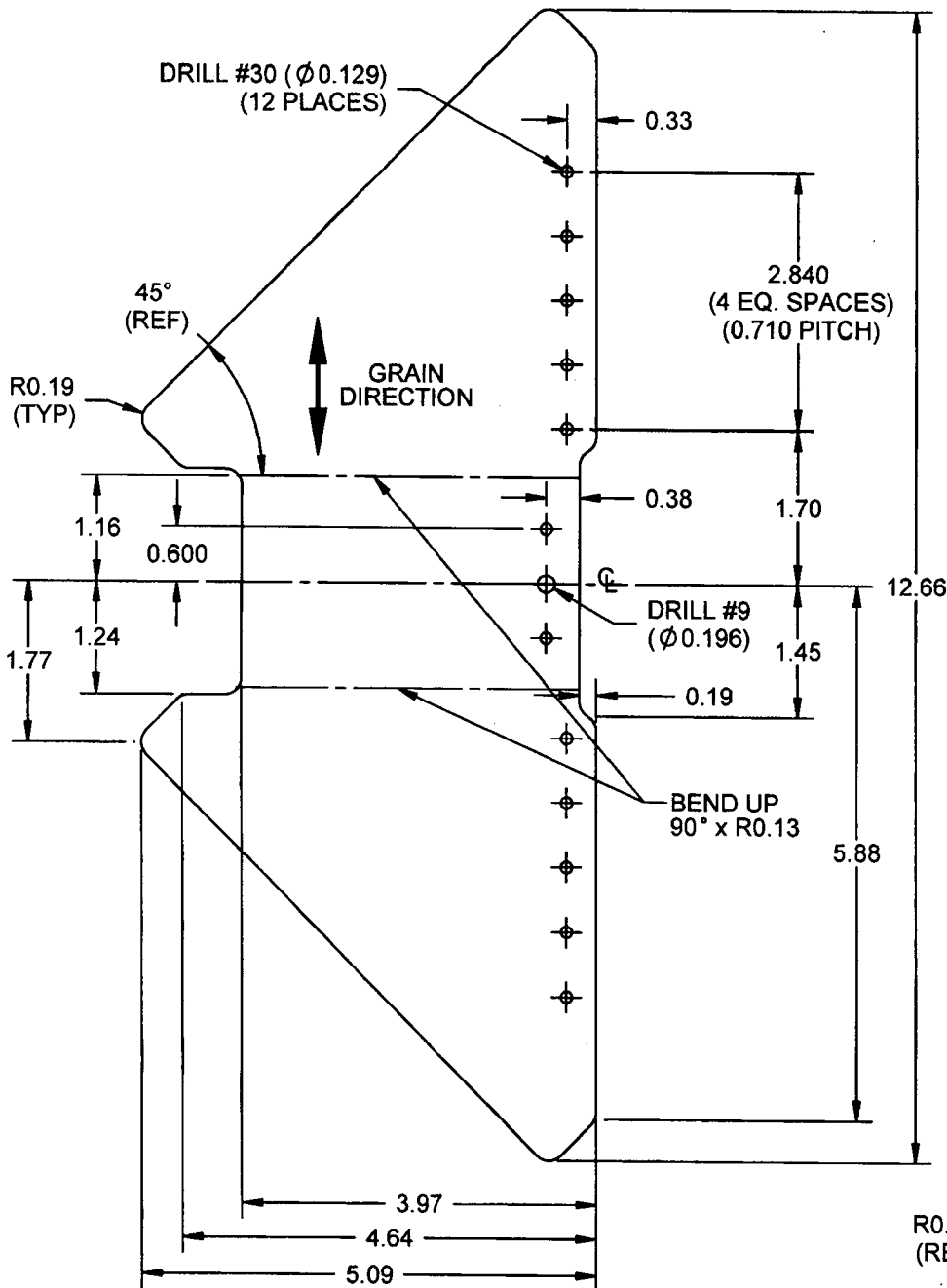
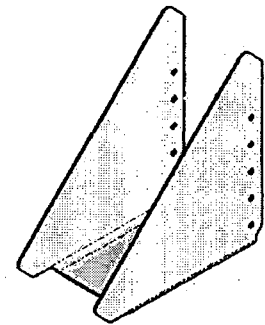
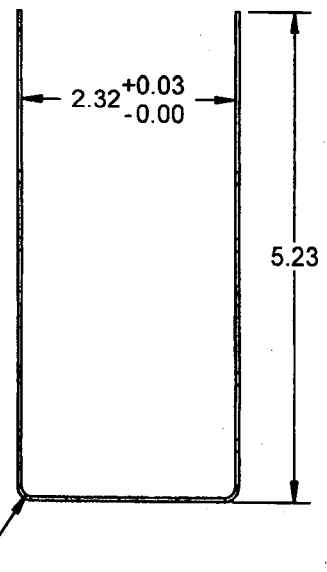
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NOTE: Date & initial all entries

DART

77184

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3531	REV. A
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SHEET 2 OF 3 SCALE 1:2

**D3531-1F FLAT PATTERN****RELEASED**
07.08.03**D3531-1 BRACKET****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

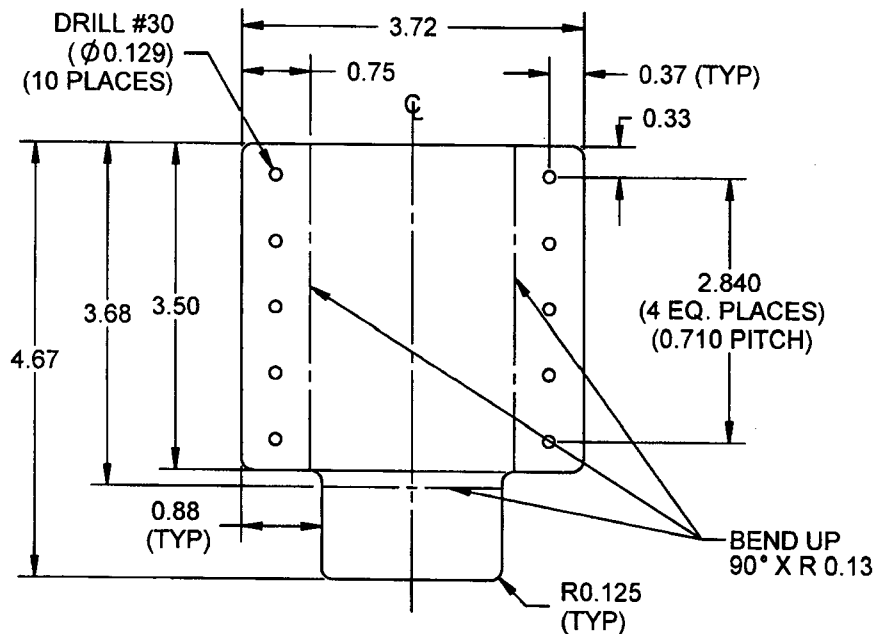
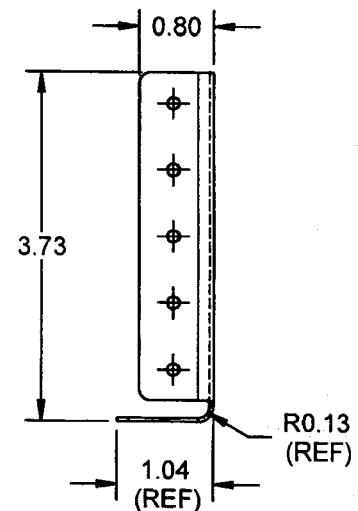
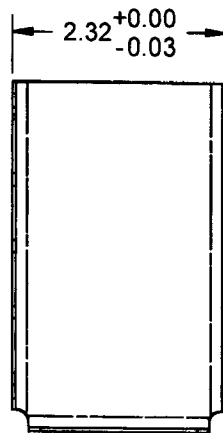
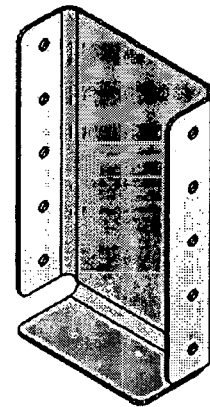
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DART

77184

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED CE	APPROVED #	DRAWING NO. D3531
DATE 07.06.19	TITLE BRACKET ASSEMBLY	REV. A SHEET 3 OF 3 SCALE 1:2

**D3531-3F FLAT PATTERN****RELEASED**
07.08.03 #**D3531-3 BRACKET FRONT PLATE****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries